

Work Order ID 117564

Friday, April 25, 2014 11:51:32 AM

117564

Page 1

Item ID: D3564-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Wearplate Aft

Stop

NS2

Start Date: 4/25/14

Start Qty: 10.00

10

Cust Item ID:

Required Date: 5/02/14

Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan: *[Signature]*

Date: 14-4-15

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
|----------|--------------|

| | |
|-------|-------|
| D3564 | Rev D |
|-------|-------|

| | | | | |
|-----|------|----|---|-----------|
| 100 | 0.00 | 10 | 0 | Jm14-05-1 |
|-----|------|----|---|-----------|

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

304.063

1-Cut as per Dwg D3564 ***** (D3564-1F)***** Dwg Rev: D Prog
Rev: D 2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.00

10 0 Jm14-05-1

120

QC8- Inspect parts - second check

0.00

120

QC

Quality Control

Memo

0.00

DAS
27
9-29
14/5/12

10 MH 14/05/12

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

| | | | | | | | | | |
|-------------------|----------------------|-------|-----------|----------------------------|-----------|---------------------|-------------|--|--|
| Work Order: _____ | DISPOSITION | | | AGAINST DEPARTMENT/PROCESS | | | | | |
| Part No. _____ | Rework | Scrap | Use-as-is | Skid-tube | Crosstube | Water Jet | Engineering | | |
| NCR No. _____ | Suspected Unapproved | | | Machining | Small Fab | Prod. Eng. Coor. | Quality | | |
| | | | | Thermoforming | Finishing | Rec/Store/Packaging | Other | | |
| | | | | Large Fab | Composite | Supplier | | | |

| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| | | | | | | | | | | | |
|---|--|--|--|---|--|---|--|--|--|--|--|
| Landing Gear | | General | | | | | | | | | |
| <ul style="list-style-type: none"> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | <ul style="list-style-type: none"> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function | <input type="checkbox"/> Folio/Program | | <input type="checkbox"/> Outside Dimensions | | <input type="checkbox"/> Pressure/Forced | | | | | |
| | | <input type="checkbox"/> Grain | | <input type="checkbox"/> Over/Under tolerance | | <input type="checkbox"/> Set-up | | | | | |
| | | <input type="checkbox"/> Hardware | | <input type="checkbox"/> Part Incorrect | | <input type="checkbox"/> Temperature/Cure | | | | | |
| | | <input type="checkbox"/> Inspection Incomplete/Unqualified | | <input type="checkbox"/> Part Lost/Missing | | <input type="checkbox"/> Weld | | | | | |
| | | <input type="checkbox"/> Instructions Incomplete/Unclear | | <input type="checkbox"/> Part Moved | | <input type="checkbox"/> Wrong Stock Pulled | | | | | |
| | | <input type="checkbox"/> Misaligned/off center | | <input type="checkbox"/> Positioned Wrong | | | | | | | |
| | | <input type="checkbox"/> Mislabeled | | <input type="checkbox"/> Power Loss/Surge | | | | | | | |
| | | <input type="checkbox"/> Misread | | | | | | | | | |
| | | <input type="checkbox"/> Off-set | | | | | | | | | |
| | | <input type="checkbox"/> Out of Calibration | | | | | | | | | |
| | | <input type="checkbox"/> Out of Sequence | | | | | | | | | |
| | | | | | | | | | | | |
| | | | | | | | | | | | |
| | | | | | | | | | | | |

Work Order ID 117564

Friday, April 25, 2014 11:51:32 AM

117564

Page 2

Item ID: D3564-3

Revision ID:

Item Name: Wearplate Aft

Start Date: 4/25/14

Start Qty: 10.00 *10*

Required Date: 5/02/14

Req'd Qty: 10.00 *10*

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

130

Brake NC

NC BRAKE

0.00

DAS

30

989

10

14/05/05

Brake NC

Memo

0.00

Deburr if necessary Form on Brake as per Dwg D3564 using Jigs DT8179 and DT8155 Form Joggle as per Dwg D3564 on brake using Jig DT8157

140

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Sh
14/05

10

150

150

Large Fab

Large Fab

0.00

Memo

0.00

Qty Description Batch A/R 2059B Hardcoat
M127737 Weld hardcoat as per Dwg D3437

7

14-05-13 MAL

PTO →

DQA:

201

Date: 14/06/03

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed:

OK

Date: 14/5/22

Work Order update only

| Work Order: | DISPOSITION | | | AGAINST DEPARTMENT/PROCESS | | | | | | | | | | | | | | |
|-------------|-------------|-------|-----------|----------------------------|-----------|---------------|-----------|-----------|-----------|-----------|-----------|-------------------------------------|------------------|---------------------|----------|-------------|---------|-------|
| | Rework | Scrap | Use-as-is | Skid-tube | Machining | Thermoforming | Large Fab | Crosstube | Small Fab | Finishing | Composite | Water Jet | Prod. Eng. Coor. | Rec/Store/Packaging | Supplier | Engineering | Quality | Other |
| 117564 | | | | | | | | | | | | <input checked="" type="checkbox"/> | | | | | | |
| D3564-3 | | | | | | | | | | | | | | | | | | |
| 14-3889 | | | | | | | | | | | | | | | | | | |
| | | | | | | | | | | | | | | | | | | |

| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|----------|------|-----|---|-------------------|-------------------------|-------------|---------------------|--------------|
| Design | | | | | | | | | |
| Doc/Data | 14/05/13 | 150 | (3) | found before welding that material was too thin (.045") | DAS 16 9-89 | Scrap 3 part no replace | 14-05-13 | DAS 9 9-89 14/05/13 | DAS 16 9-89 |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | ✓ | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| Landing Gear | | General | | | | | | | | | | | | | | |
|--------------|--------------------------|---------|----------------------|--|-----------------------------------|--|--|--|--|--|--|----------------------|--|--------------------|--|--|
| | Bending | | Bend | | Folio/Program | | | | | | | Outside Dimensions | | Pressure/Forced | | |
| | Centre Not Concentric | | BOM/Route | | Grain | | | | | | | Over/Under tolerance | | Set-up | | |
| | Cracks | | Broken/Damage/Defect | | Hardware | | | | | | | Part Incorrect | | Temperature/Cure | | |
| | Crimp/Kink/Ripple/Wave | | Burrs | | Inspection Incomplete/Unqualified | | | | | | | Part Lost/Missing | | Weld | | |
| | Cuffs | | Contamination | | Instructions Incomplete/Unclear | | | | | | | Part Moved | | Wrong Stock Pulled | | |
| | Crushing | | Countersink | | Misaligned/off center | | | | | | | Positioned Wrong | | | | |
| | Heat Treat | | Cut Too Short | | Mislabeled | | | | | | | Power Loss/Surge | | Other | | |
| | Inspection Strip in Tube | | Drawing | | Misread | | | | | | | | | | | |
| | Marks/Chatter | | Drill Holes | | Off-set | | | | | | | | | | | |
| | Turning Sequence | | Finish | | Out of Calibration | | | | | | | | | | | |
| | Wave/Twist in Tube | | Fit/Function | | Out of Sequence | | | | | | | | | | | |

Work Order ID 117564

Friday, April 25, 2014 11:51:32 AM

117564

Page 3

Item ID: D3564-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Wearplate Aft

Stop

NS2

Start Date: 4/25/14

Start Qty: 10.00

10

Cust Item ID:

Required Date: 5/02/14

Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC10- Inspect visual per QSI004- ground welds

0.00

DAS

160

QC

Memo

0.00

①

140503

Quality Control

170

QC5- Inspect part completeness to step on W/O

0.00

DAS

170

QC

Memo

0.00

①

1405-13

Quality Control

180

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

1405028

Memo

0.00

START TIME: 9:05 OPEN TEMPERATURE:
FINISH TIME: 9:35

②

14-5-16.

25489

180

Powdercoat

Powder Coating

DQA: _____ Date: _____

QA Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only

| | | | | | | | | | | | | | |
|--------------------------|------|----------------------|-------|---|-----------------------------------|----------------------|--------------------|-----------------|-------------|--------------|------------------|---------------------|-------------|
| Work Order: _____ | | DISPOSITION | | | AGAINST DEPARTMENT/PROCESS | | | | | | | | |
| Part No. _____ | | Rework | Scrap | Use-as-is | Skid-tube | Machining | Thermoforming | Large Fab | Crosstube | Small Fab | Finishing | Water Jet | Engineering |
| NCR No. _____ | | Suspected Unapproved | | | | | | | | | Prod. Eng. Coor. | Rec/Store/Packaging | Supplier |
| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | | Initial Chief Eng | Action Description | | Sign & Date | Verification | QC Inspector | | |
| Design | | | | | | | | | | | | | |
| Doc/Data | | | | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | | | | |
| Handling/Pre | | | | | | | | | | | | | |
| Material | | | | | | | | | | | | | |
| Operator | | | | | | | | | | | | | |
| Offset/Setup | | | | | | | | | | | | | |
| Process | | | | | | | | | | | | | |
| Supplier | | | | | | | | | | | | | |
| Training | | | | | | | | | | | | | |
| Transport | | | | | | | | | | | | | |
| Unapproved | | | | | | | | | | | | | |
| FAULT CATEGORY | | | | | | | | | | | | | |
| Landing Gear | | | | General | | | | | | | | | |
| | | | | Bending | Bend | Folio/Program | Outside Dimensions | Pressure/Forced | | | | | |
| Centre Not Concentric | | | | BOM/Route | Grain | Over/Under tolerance | Set-up | | | | | | |
| Cracks | | | | Broken/Damage/Defect | Hardware | Part Incorrect | Temperature/Cure | | | | | | |
| Crimp/Kink/Ripple/Wave | | | | Burrs | Inspection Incomplete/Unqualified | Part Lost/Missing | Weld | | | | | | |
| Cuffs | | | | Contamination | Instructions Incomplete/Unclear | Part Moved | Wrong Stock Pulled | | | | | | |
| Crushing | | | | Countersink | Misaligned/off center | Positioned Wrong | | | | | | | |
| Heat Treat | | | | Cut Too Short | Mislabeled | Power Loss/Surge | Other | | | | | | |
| Inspection Strip in Tube | | | | Drawing | Misread | | | | | | | | |
| Marks/Chatter | | | | Drill Holes | Off-set | | | | | | | | |
| Turning Sequence | | | | Finish | Out of Calibration | | | | | | | | |
| Wave/Twist in Tube | | | | Fit/Function | Out of Sequence | | | | | | | | |

Work Order ID 117564

Friday, April 25, 2014 11:51:32 AM

117564

Page 4

Item ID: D3564-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Wearplate Aft

Stop

NS2

Start Date: 4/25/14

Start Qty: 10.00

10

Cust Item ID:

Required Date: 5/02/14

Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC3- Inspect Part Finish

0.00

DAS

27

9.49

14/5/16

100

QC

Quality Control

200

Identify as per dwg & Stock Location: FP-002

0.00

200

Packaging

Packaging

0.00

x 7 d 14/5/2016

210

QC21- Final Inspection - Work Order Release

0.00

210

QC

Quality Control

0.00

14/5/2016

MF
14-5-20

DQA: _____ Date: _____

Date:

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Date:

Work Order update only

| Work Order: _____ | | | DISPOSITION | | | AGAINST DEPARTMENT/PROCESS | | | | | |
|---|------|------|---|--|--|--|---|--------------|--------------|--|--|
| | | | Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/> | Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> | Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> | Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> | Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> | | | | |
| Part No. _____ | | | | | | | | | | | |
| NCR No. _____ | | | | | | | | | | | |
| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector | | |
| Design <input type="checkbox"/> | | | | | | | | | | | |
| Doc/Data <input type="checkbox"/> | | | | | | | | | | | |
| Equip/Tooling <input type="checkbox"/> | | | | | | | | | | | |
| Handling/Pre <input type="checkbox"/> | | | | | | | | | | | |
| Material <input type="checkbox"/> | | | | | | | | | | | |
| Operator <input type="checkbox"/> | | | | | | | | | | | |
| Offset/Setup <input type="checkbox"/> | | | | | | | | | | | |
| Process <input type="checkbox"/> | | | | | | | | | | | |
| Supplier <input type="checkbox"/> | | | | | | | | | | | |
| Training <input type="checkbox"/> | | | | | | | | | | | |
| Transport <input type="checkbox"/> | | | | | | | | | | | |
| Unapproved <input type="checkbox"/> | | | | | | | | | | | |
| FAULT CATEGORY | | | | | | | | | | | |
| Landing Gear | | | General | | | | | | | | |
| <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | | | <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function | | | | | | | | |
| | | | <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence | | | | | | | | |
| | | | <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge | | | | | | | | |
| | | | <input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled | | | | | | | | |
| | | | <input type="checkbox"/> Other | | | | | | | | |

Checklist Print

Friday, April 25, 2014 11:51:32 AM

Page 1

Work Order ID: 117564

117564

Parent Item: D3564-3

D3564-3

Parent Item Name: Wearplate Aft

Start Date: 4/25/14

Required Date: 5/02/14

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 07-03-08 ec
 IPP Rev:B As per Rev C 07-07-09 JLM
 IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M304S16GA | | Purchased | | No | | 100 | sf | 123.2670 | 1.1 | 12 | ** | JM14-05-1 | |

M304S16GA

304/316 Sheet .063

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| MAT020 | 123.267 | |
| M126915 | 0.737 | |
| M127821 | 122.53 | 127821 |

DQA: _____ Date: _____

QA Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only

| | | | | | | | | | | | | | | | |
|---|--|------|---|--|---|------------------------------------|------------------------------------|---|--------------------------------------|--------------|--------------|--|--|--|--|
| Work Order: _____ | | | DISPOSITION | | | AGAINST DEPARTMENT/PROCESS | | | | | | | | | |
| Part No. _____ | | | Rework <input type="checkbox"/> | Scrap <input type="checkbox"/> | Use-as-is <input type="checkbox"/> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | | | | | | |
| NCR No. _____ | | | Suspected Unapproved <input type="checkbox"/> | | | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coor. <input type="checkbox"/> | Quality <input type="checkbox"/> | | | | | | |
| Thermoforming <input type="checkbox"/> | | | Large Fab <input type="checkbox"/> | | | Finishing <input type="checkbox"/> | Composite <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | | | | | | |
| Root Cause | | Date | Step | Qty | Description of work order update or non-conformance | | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector | | | | |
| Design | | | | | | | | | | | | | | | |
| Doc/Data | | | | | | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | | | | | | |
| Handling/Pre | | | | | | | | | | | | | | | |
| Material | | | | | | | | | | | | | | | |
| Operator | | | | | | | | | | | | | | | |
| Offset/Setup | | | | | | | | | | | | | | | |
| Process | | | | | | | | | | | | | | | |
| Supplier | | | | | | | | | | | | | | | |
| Training | | | | | | | | | | | | | | | |
| Transport | | | | | | | | | | | | | | | |
| Unapproved | | | | | | | | | | | | | | | |
| FAULT CATEGORY | | | | | | | | | | | | | | | |
| Landing Gear | | | | General | | | | | | | | | | | |
| <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | | | | <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function | | | | <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence | | | | <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge | | <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled | |
| | | | | | | | | | | | | <input type="checkbox"/> Other | | | |
| | | | | | | | | | | | | | | | |
| | | | | | | | | | | | | | | | |

| | | |
|------------------------------|---------------------|-------------|
| DART AEROSPACE LTD | Work Order: | 117564 |
| Description: Wearshoe | Part Number: | D3564-3 |
| Inspection Dwg: D3564 | Rev: D | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

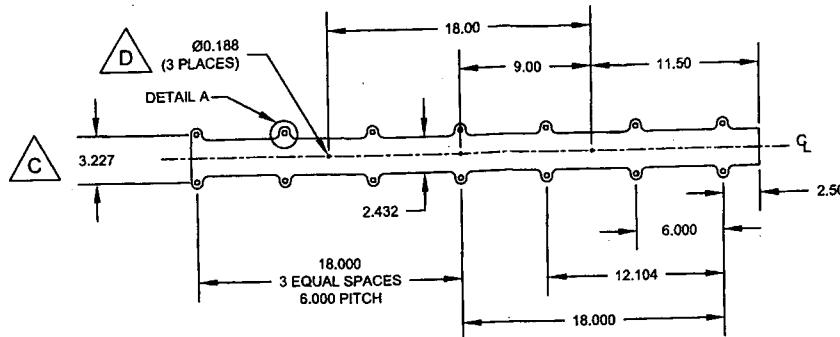
X First Article Prototype

27

| | | | | | |
|--------------|---------|-------------|----------|---------------------|-----|
| Measured by: | JM | Audited by: | MH 9-29 | Prototype Approval: | N/A |
| Date: | 14-05-1 | Date: | 14/05/02 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------------|------------|----------|
| A | 07.09.06 | New Issue | KJ/JLM | |
| B | 08.09.04 | Dwg Rev updated | KJ/DD | |

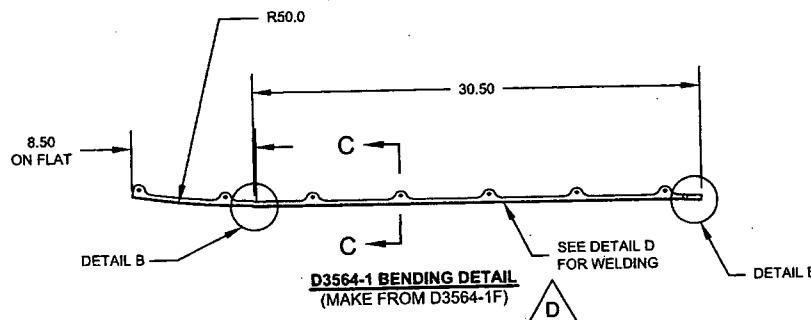
8 7 6 5 4 3 2 1



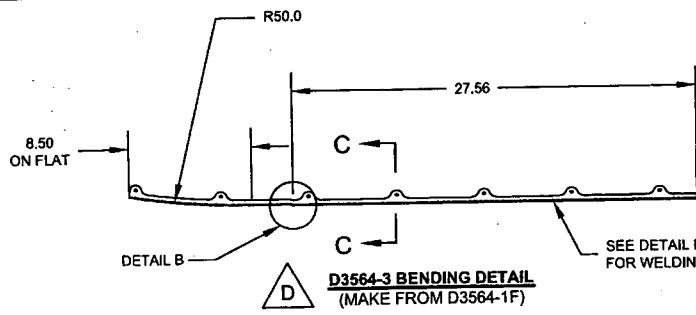
D3564-1F FLAT PATTERN

117564 N
11-4-25

RELEASED
07.09.04



D3564-1 BENDING DETAIL
(MAKE FROM D3564-1F)



UNDER REVIEW
11-4-25
OK 11-11-26
Fwd. change

D3564-1/-3/-5/-7/-9/-11/-13/-15 WEARPLATE NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) WELD PER DART QSI 004
- 9) SEE PG 3 FOR SECTIONS AND DETAILS
- 10) PARTS ARE SYMMETRIC ABOUT $\frac{1}{2}$

8 7 6 5 4 3 2 1

| WEIGHTS: | |
|----------|----------|
| D3564-1 | 1.85 lbs |
| D3564-3 | 1.85 lbs |
| D3564-5 | 1.93 lbs |
| D3564-7 | 1.26 lbs |
| D3564-9 | 1.85 lbs |
| D3564-11 | 1.85 lbs |
| D3564-13 | 0.38 lbs |
| D3564-15 | 0.80 lbs |

DATE 07.08.21

| REV. | DESCRIPTION | BY | DATE |
|------|---------------|----|-----------------------------|
| PH | DESIGN | CB | DART AEROSPACE LTD |
| CB | DRAWN | CB | HAWKESBURY, ONTARIO, CANADA |
| PH | CHECKED | PH | DRAWING NO. D3564 |
| CB | MFG. APPR. | CB | REV. D |
| CB | APPROVED | CB | SHEET 1 OF 3 |
| CB | DE APPR. | CB | TITLE WEARSHOE |
| CB | DATE 07.08.21 | CB | SCALE 1:8 |

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